

Work Order ID 151344***151344***

Page 1

Friday, September 23, 2016 8:23:32 AM

Item ID: D2796

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cross Beam

Start Date: 9/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/4/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2796	Rev U R								
105	*105* Mill Conv Conventional Milling Machine	0.00				1	0		DAS 32 9-89 16-09-26
	Memo PULL FROM STOCK: 1 X D2764 B 43811 DRILL HOLES PER DRWG D2796 REV.C	0.00							
107	QC2- Inspect parts off machine FAI/FAIB	0.00				1	0		DAS 32 9-89 16-09-26
	107 QC Quality Control	0.00							
	Memo	0.00							
112	QC8- Inspect parts - second check	0.00							
	112 QC Quality Control	0.00							DAS 08 9-89
	Memo	0.00							

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151344

Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

TOUCH UP ALODINE

(x1) ~~0~~ 2016/09/26
BEB.

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

140

Powdercoat

M B54R.

Memo

0.00

Powder Coating

TOUCH UP POWDER COAT

START: 1:40
cu. T: 3200
FINISH: 2:10

1 ~~0~~ 1609-26. DAS 34 9-89

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

DAS
38
9-89

SEP 26 2016

Work Order ID 151344***151344***

Page 3

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: *SK*

0.00

160

Packaging

Memo

0.00

Packaging

/ SEP 27 2016

DAS
6
9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

DAS
21
9-89

SEP 27 2016

Picklist Print

Friday, September 23, 2016 8:23:31 AM

Page 1

Work Order ID: 151344

151344

Parent Item: D2796

D2796

Parent Item Name: Cross Beam

Start Date: 9/23/2016

Required Date: 10/4/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2764		Manufactured	No				Each	3.0000		1			DAS
D2764									**			16-09-26	32
Cross Beam													9-89

Location

Loc Qty

Loc Code

Mezz

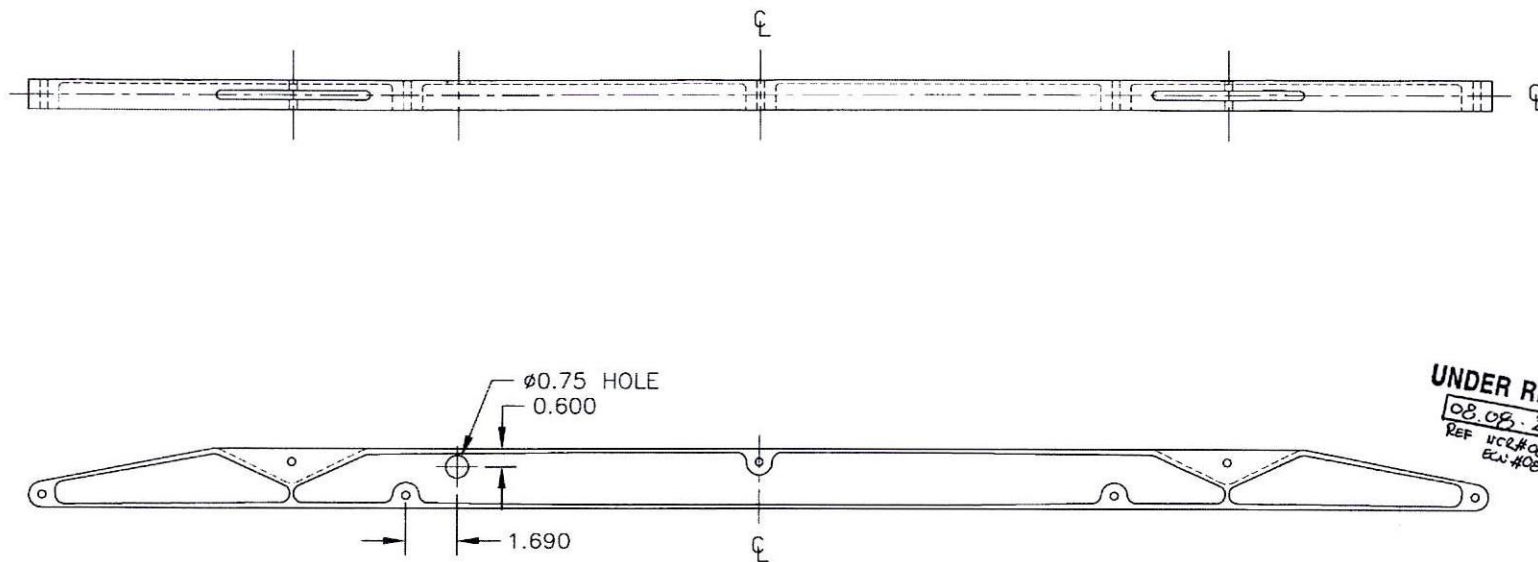
3

43811

3

1

46 151344



UNDER REVIEW
08.09.21
REF: 102#05-096
ECN #08-515

RELEASED
99.11.18 KE



MATERIAL: MAKE FROM D2764
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

C	98.11.09	REMOVED WIRE SLOT, TAPERED WALLS
B	98.09.02	MACHINED PART WAS BOX BEAM
A	98.06.30	NEW ISSUE
DESIGN KE	DRAWN BY KE	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED KE	APPROVED KE	DRAWING NO. D2796
DATE 98.11.09	TITLE MIDDLE CROSS BEAM	REV. C SHEET 1 OF 1 SCALE 1:4